

Work Order ID 66167

Monday, February 07, 2011 11:32:07 AM

Page 1

Item ID: D3908-1

Accept

Revision ID:

Item Name: Lug Plate, Aft Crosstube

Start Date: 2/8/2011 Start Qty: 10.00

Required Date: 2/22/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date: 11-02-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 .125

Cut as per dwg D3908

Prog Rev: C

Dwg Rev: C

Deburr as required

11-2-15

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-2-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3908-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Aft Crosstube

Start Date: 2/8/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/16/15

(410)

Quality Control

150

Identify as per dwg & Stock Location: 90

0.00



Packaging

Memo

0.00

11/2/15 102 SP

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

OK 11/02/16

Quality Control

11-02-15

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Monday, February 07, 2011 11:32:02 AM

Page 1

Work Order ID: 66167



Parent Item: D3908-1



Parent Item Name: Lug Plate, Aft Crosstube


Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC IPP Rev:B as
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per PC1
10.05.27 DD verf:EC IPP Rev:D per ECN10-581 10.05.28
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	52.2800	0.0533	0.561053			



1811-2-15

Location

Loc Qty

Loc Code

MAT

52.28

116623

52.28

116623

(10)

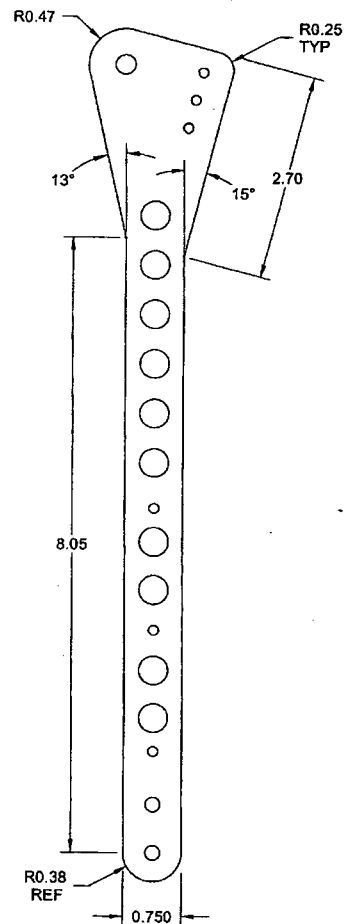
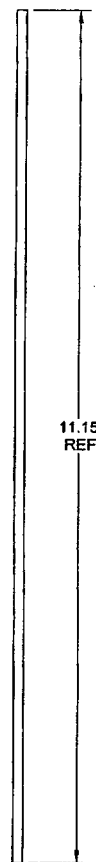
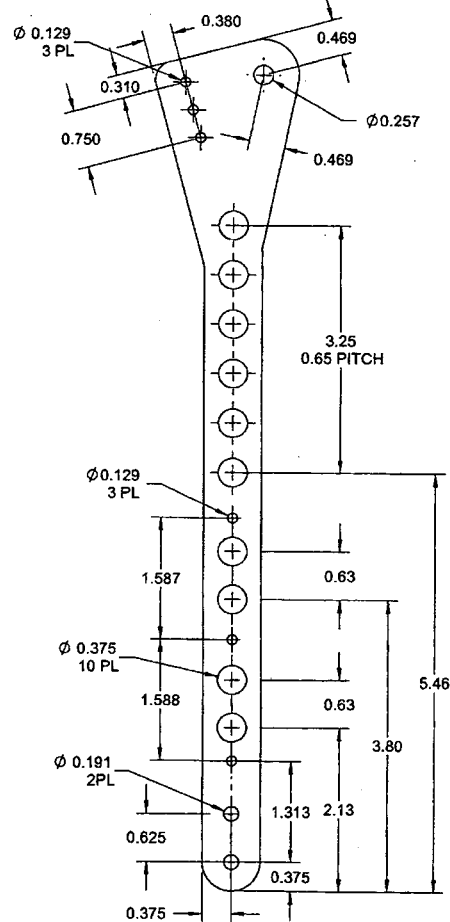
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


#66167

RELEASED
2010-05-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 66167
Description: Lug Plate, Aft Crosstube		Part Number: D3908-1
Inspection Dwg: D3908	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	X		✓ RB02	
Ø0.191	+0.005/-0.001	.195	X		✓	
Ø0.257	+0.006/-0.001	.261	X		✓	
Ø0.375	+0.006/-0.001	.378	X		✓	
0.310	+/-0.010	.307	X		✓	
0.380	+/-0.010	.383	X		✓	
0.750	+/-0.010	.753	X		✓	
0.469	+/-0.010	.470	X		✓	
3.25	+/-0.030	3.250	>		✓	
0.65	+/-0.030	.656	X		✓	
0.63	+/-0.030	.631	>		✓	
1.587	+/-0.010	1.587	>		✓	
1.588	+/-0.010	1.589	>		✓	
5.46	+/-0.030	5.462	>		✓	
3.80	+/-0.030	3.802	>		✓	
2.13	+/-0.030	2.126	>		✓	
1.313	+/-0.010	1.313	>		✓	
0.375	+/-0.010	.374	X		✓	
0.625	+/-0.010	.627	X		✓	
11.15	+/-0.030	11.149	>		PRO WS 02	
0.375	+/-0.010	.378	X		✓	
0.750	+/-0.010	.758	X		✓	
0.125	+/-0.010	.118	X		✓	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 11-2-15	Date: 11/02/15	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dimensions updated per Dwg Rev B	KJ	
C	10.06.07	Dimensions updated per Dwg Rev C	KJ	

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